

Date: Monday, 11/21/2005 11:55:18 AM
User: Linda Lacelle

Process Sheet

SLPI E-1

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: RADIUS BLOCK		
Job Number	: 24872						
Estimate Number	: 10822						
P.O. Number	: N/A			Part Number	: D2274		
This Issue	: 11/21/2005	S.O. No.	: N/A	Drawing Number	: D2274 REV F		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: N/A	Type	: MACHINED PARTS	Drawing Revision	: F		
Previous Run	: N/A			Material	: N/A		
Written By	: See comment below			Due Date	: 12/15/2005		
Checked & Approved By	: See comment below			Qty:	580 Um: Each		
Comment	: Est. H 00.05.18 Added inspection level 8 EC						

Additional Product

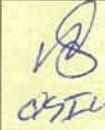
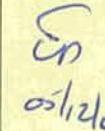
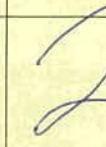
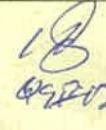
Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0750X00125	6061-T6 Bar .75" x .125" 
	Comment: Qty.: 0.0962 f(s)/Unit Total: 48.0900 f(s) 6061-T6 Bar .75" x .125" Shear blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces Material: 6061-T6 (QQ-A-250/11) or 5052-H34 (QQ-A-250/8) 1/8" X 3/4" BarBatch <u>117599</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 
	Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2274	 En 05/12/06 539
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	Ep 05/12/06 539
4.0	QC8	SECOND CHECK 
	Comment: SECOND CHECK	gml 05/12/06 539
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble Deburr any rough edges after tumbling	FF 05.12.08 56

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 05/12/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05/12/06	# 2	10 parts scrap Parts poped frontal size	 05/12/06	Scrap and Replace	 05/12/06	 05-12-06	 05/12/06	 05-12-06

NOTE: Date & initial all entries

Date: Monday, 11/21/2005 11:55:18 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RADIUS BLOCK

Job Number: 24872

Part Number: D2274

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



56

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 05-12-08

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

cL 0512109 56

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

cL 0512109 56

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Suc 05/12/12 56

(D) 05/12/12 56

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

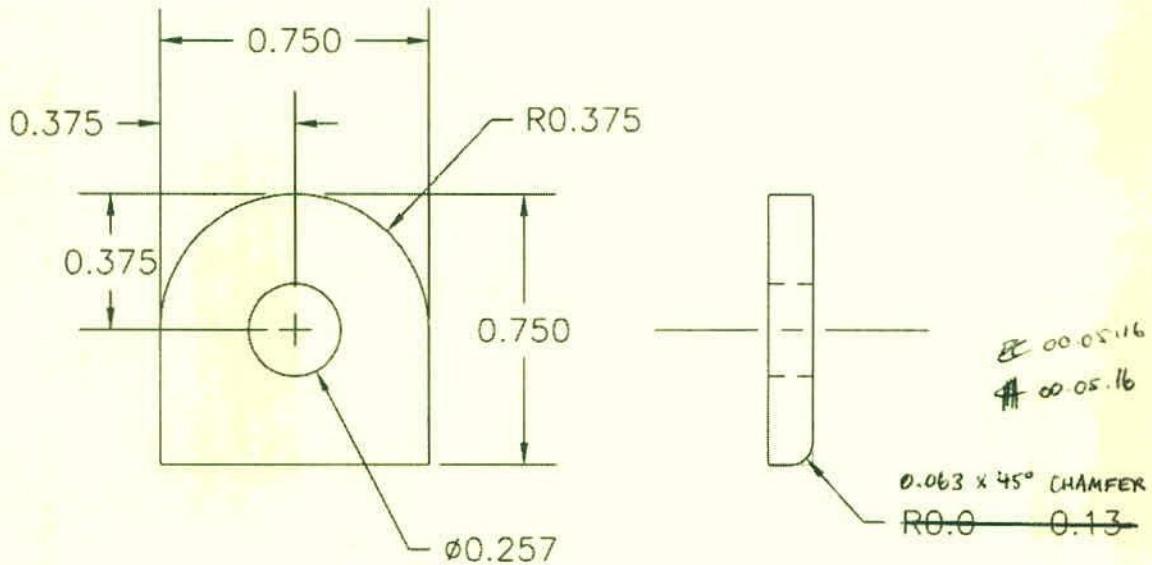
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MDY</i>	APPROVED <i>GS</i>	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED
 98/08/18 KE


MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
 OR 6061-T6 (QQ-A-250/11) 0.125 THICK

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED



DART AEROSPACE LTD	Work Order:	
Description: Radius Block	Part Number:	D2274
Inspection Dwg: D2274	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>BG</u>	Audited by:	<u>SD</u>	Prototype Approval:	
Date:	05.12.05	Date:	05.12.05	Date:	

Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	



Job Costing Report

Dart Aerospace Ltd.
HawkesburyNov 18, 2005
09:21 am

Work Order No : 0024872
 Project Name : D2274 Department Code:
 Project For : WK550 Burden Flags : NNNNNNN
 Work Order Type : Main WO Status : Open
 Main WO Number : Invoice State : Not Invoiced
 House Part Number : D2274 Invoice Date :
 Description : Radius Block Invoice Number :
 Manufactured : Yes Invoice Amount : 0.00
 Amount Req'd : 500
 Amount Done : 0 Order Entry No :
 Start Date : 11-18-05 OE Value : 0.00
 Est Finish Date : 12-15-05
 Act Finish Date : Est Margin : 0.000%
 Drawings Reqd : No Actual Margin : 0.000%
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00